

Date: Tuesday, 27/01/2009 1:27:28 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG BRACKET		
Job Number	: 45296			Part Number	: D2658		
Estimate Number	: 10339			Drawing Number	: D2658 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 27/01/2009 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 15/02/2009		
Previous Run	: 44217B			Qty:	20	Um:	Each
Written By	:			(Signature)			
Checked & Approved By	:			(Signature)			
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-08-23 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S12GA	1010/102 mild steel sheet 12ga  Comment: Qty.: 0.1197 sf(s)/Unit Total : 2.3940 sf(s) 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK Batch: 101094 B 9-2-7
2.0	WATER JET	FLOW WATER JET  Comment: FLOW WATER JET 1-Cut as per Dwg D2858 Dwg Rev: <u>1</u> Prog Rev: <u>1</u> B 9-2-7 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE B 9-2-7
4.0	QC8	SECOND CHECK  Comment: SECOND CHECK  809/02/09 X28 <i>counts</i>
5.0	BRAKE NC	NC BRAKE  Comment: NC BRAKE 1-Deburr as required.  2-Bend on CNC brake using DT8254 identify as D2658  809 09/02/20 <i>258</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



for 02-20



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CAROCK BOOTH / WA*

EL 9-2-20

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF
09-02-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	45396
Description: LUG BRACKET	Part Number:	D3658
Inspection Dwg: 2658 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by: HB	Audited by: S	Prototype Approval: A
Date: 9-27	Date: 09/27/03	Date: A

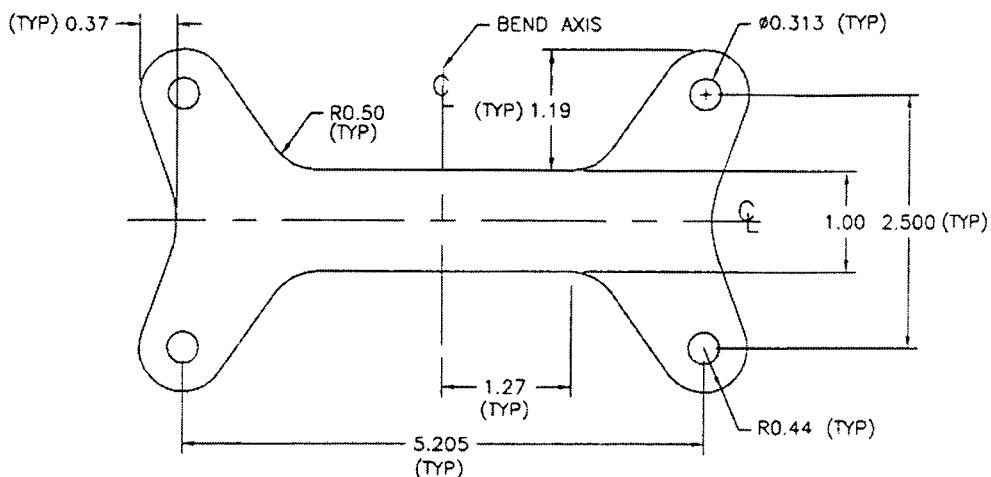
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

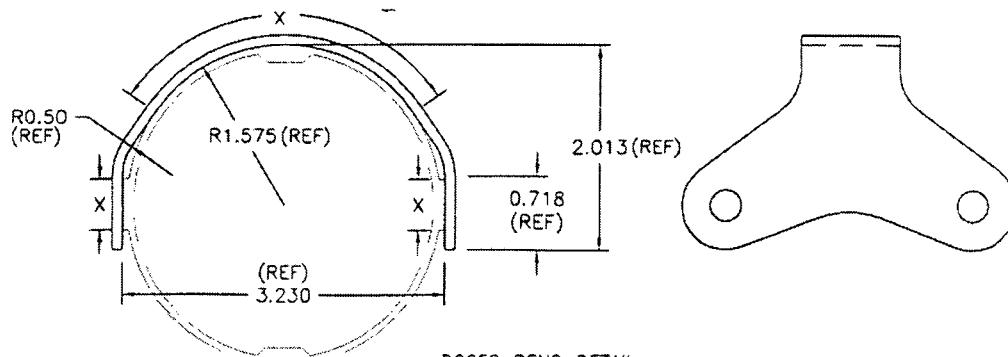
5 COPY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2658	SHEET 1 OF 1
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries